

Work Order ID 69353

Monday, May 09, 2011 4:03:03 PM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 5/9/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								
100	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563								
	2-Deburr ends								
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343								
	4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

AE

5 0 11-04-10

11-05-11 5 0

5 0 11/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>75</u>			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							5X ϕ m.d 11/05/12
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							5 BX 11-5-12

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>1114703</u> Large Fab	0.00							
	Memo	0.00							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
	Quality Control								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

175

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

5. PR 11-5-13

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50
320 °F
9:20

5x of ml 11/5/13

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

5 PR 11-5-16.

M116964

M11735

W/O:		WORK ORDER CHANGES						
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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5x 11/05/17

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

RIP
69352

11/05/20 11

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24
MF
11-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, May 09, 2011 4:03:10 PM

Page 1

Work Order ID: 69353

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 5/9/2011


Required Date: 5/11/2011

Start Qty: 5.00


Required Qty: 5.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116  Step Extrusion		Manufactured	No			100	Each	152.0000	1	5		5/11/05/10	
--	--	--------------	----	--	--	-----	------	----------	---	---	--	------------	--


Location	Loc Qty	Loc Code
HALL	94	
60307	94	
WA	58	
57850	16	
60307	42	

D2561  Lug		Manufactured	No			100	Each	9.0000	2	10		5/11/05/10	
---	--	--------------	----	--	--	-----	------	--------	---	----	--	------------	--

Location	Loc Qty	Loc Code
WA015	9	
66813	9	

D2564  Mounting Angle		Manufactured	No			100	Each	25.0000	2	10		5/11/05/10	
--	--	--------------	----	--	--	-----	------	---------	---	----	--	------------	--

Location	Loc Qty	Loc Code
WA	25	
66984	25	

D2673-34  End Plate		Manufactured	No			100	Each	89.0000	1	5		5/11/05/10	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	------------	--

Location	Loc Qty	Loc Code
WA015	89	
59690	89	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, May 09, 2011 4:03:10 PM

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Parent Item: D2563



Parent Item Name: Step Weldment Assembly

Start Date: 5/9/2011

Required Date: 5/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2673-34

Manufactured

No

150

Each

89.0000

1

5



PL 11.05.12

End Plate

Location

Loc Qty

Loc Code

WA015

89

59690

89

5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

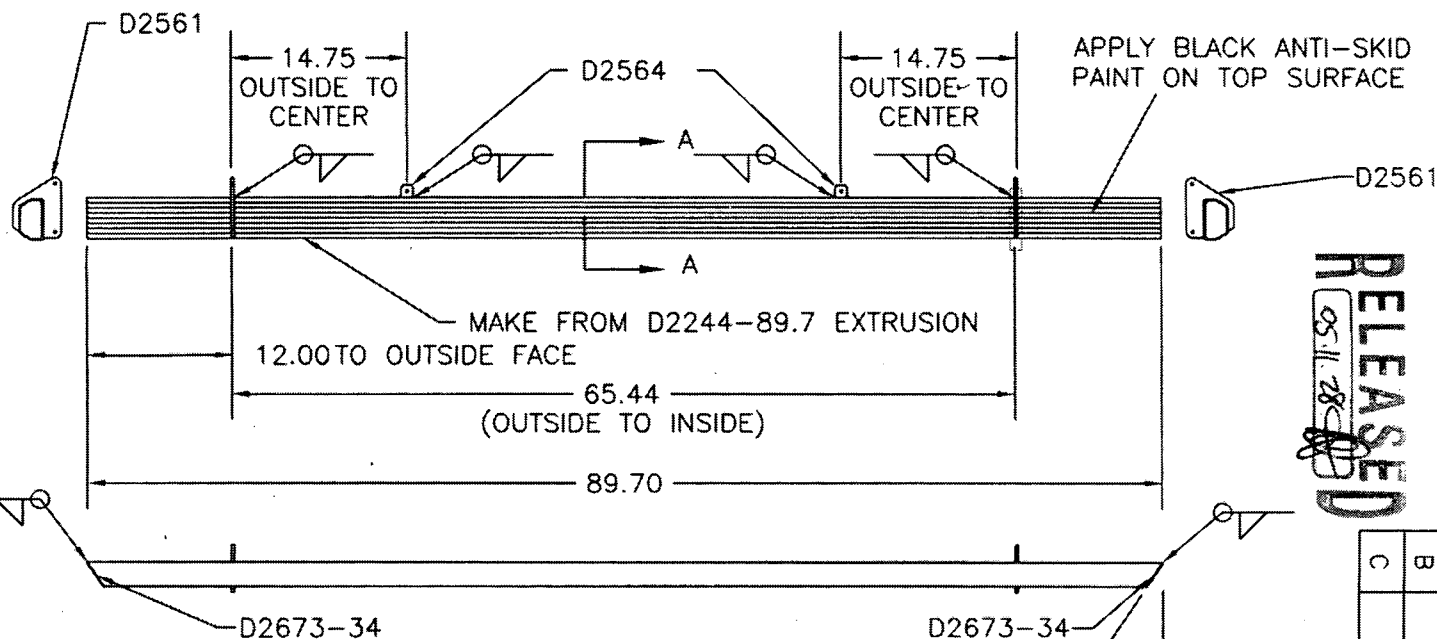
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
05.11.28

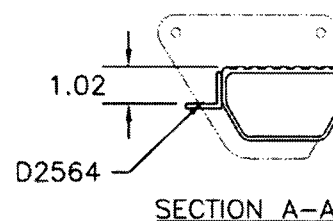


D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69353



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY
A	96.04.26	NEW ISSUE	REV. C
B	97.05.14	END CAPS CHANGED (WAS D2248)	SHEET 1 OF 1
C	05.11.14	UPDATE NOTES	SCALE 1:15

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